

Work Order ID 79648***79648***

Page 6

January-31-12 8:02:59 AM

Item ID: D205-634-141

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 1/31/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/09/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC21- Final Inspection - Work Order Release

0.00


240

QC

Memo

0.00

Quality Control

12/2/10 

12-09-9

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 79648

Parent Item: D205-634-141

Parent Item Name: Replacement Skidtube

Start Date: 1/31/12

Required Date: 2/09/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA 11.09.14 new issue EC verified by:DD
ECN11-684 DD VERF:EC

IPP REV:B 12.01.23 AS PER

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| AN4-45A Bolt | | Purchased | No | | | 210 | Each | 96.0000 | 8 | 8 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST350A | | 96 | | | | | | | |
| | | | | 118926 | | 96 | | | | | | | |
| D2500-1-190 Ext'n -I' Beam Tube 4" | | Manufactured | No | | | 110 | Each | 60.0000 | 1 | 1 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | HALL | | 60 | | | | | | | |
| | | | | 74777 | | 60 | | | | | | | |
| D2570 Bushing | | Manufactured | No | | | 210 | Each | 607.0000 | 16 | 16 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST011 | | 607 | | | | | | | |
| | | | | 72960 | | 41 | | | | | | | |
| | | | | 78585 | | 166 | | | | | | | |
| | | | | 78586 | | 200 | | | | | | | |
| | | | | 78587 | | 200 | | | | | | | |
| D2596 Web, 205 Skidtube | | Manufactured | No | | | 110 | Each | 0.0000 | 1 | 1 | | | |
| D4202-1 Spacer | | Manufactured | No | | | 150 | Each | 960.0000 | 20 | 20 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | LG | | 446 | | | | | | | |
| | | | | 77727 | | 123 | | | | | | | |
| | | | | 77729 | | 323 | | | | | | | |
| | | | | LG002 | | 514 | | | | | | | |
| | | | | 78806 | | 514 | | | | | | | |

del 12/02/09

x8

12-02-06

del 12/02/09

x16

12-2-3

CF 12-2-8

79766

| W/O: | | WORK ORDER CHANGES | | | | | |
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Page 2

Work Order ID: 79648

Parent Item: D205-634-141

Parent Item Name: Replacement Skidtube

Start Date: 1/31/12

Required Date: 2/09/12

Start Qty: 1.00

Required Qty: 1.00

D4406-041 Manufactured No 210 Each 1.0000
Fwd Wearplate Assembly

1 387116 (41) M 11/02/09

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP002 | 1 | |
| 74147 | 1 | |

D4406-043 Manufactured No 210 Each 1.0000
Aft Wearplate Assembly

1 379906 (41) M 11/02/09

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP001 | 1 | |
| 74149 | 1 | |

MS21042-4 Purchased No 210 Each 1,248.0000
USE MS21042L4

8 1119075 (8) M 12/02/09

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST299 | 1248 | |
| 100743 | 9 | |
| 119124 | 1000 | |
| 5389 | 66 | |
| 5461 | 3 | |
| 6844 | 19 | |
| 7690 | 24 | |
| 8182 | 115 | |
| 9063 | 8 | |
| 9229 | 4 | |

D2576-3 Manufactured No 150 Each 81.0000
Step (maching detail)

1 1 12/02/09

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 81 | |
| 70883 | 31 | |
| 74136 | 50 | |

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Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
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| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 79648

Parent Item: D205-634-141

Parent Item Name: Replacement Skidtube

Start Date: 1/31/12

Required Date: 2/09/12

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 210 Each 80.0000

Cap

1 12/02/09

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP002 | 80 | |
| 65519 | 2 | |
| 73347 | 30 | |
| 75074 | 48 | |

AN3-5A Purchased No 210 Each 1,254.0000

Bolt

2 12/02/09

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST350 | 1254 | |
| 115371 | 46 | |
| 117423 | 210 | |
| 118626 | 298 | |
| 119355 | 200 | |
| 120187 | 500 | |

AN960JD10L NAS1149D0332J Purchased No 210 Each 0.0000

Washer

2 11/19/09 12/02/09

D2594-3 Manufactured No 210 Each 296.0000

O-Ring, 205 Skidtube

8 12/02/09

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP001 | 296 | |
| 65518 | 41 | |
| 73490 | 255 | |

D2594-1 Manufactured No 210 Each 562.0000

Plug, 205 Skidtube

8 12/02/09

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP001 | 562 | |
| 73401 | 30 | |
| 74442 | 34 | |
| 74869 | 184 | |
| 76075 | 64 | |
| 77035 | 250 | |

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Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries

| LIST OF MATERIALS | | | | | PART NUMBER | DESCRIPTION |
|-------------------|-------------|-------------|-------------|--|---|---------------------|
| ITEM | QTY -041 | QTY -045 | QTY -047 | | | |
| 1 | X | | | | D2580-041 | SKIDTUBE ASSEMBLY |
| 2 | | X | | | D2580-045 | SKIDTUBE ASSEMBLY |
| 3 | | | X | | D2580-047 | SKIDTUBE ASSEMBLY |
| 4 | 1 | 1 | 1 | | D2500-1-190 | EXTRUSION |
| 5 | | | 16 | | D2570 | BUSHING |
| 6 | 1 | 1 | 1 | | D2576-3 | STEP |
| 7 | 20 | 24 | 25 | | D2579 | SPACER |
| 8 | 16 | 16 | 8 | | D2594-1 | PLUG |
| 9 | 16 | 16 | 8 | | D2594-3 | O-RING |
| 10 | 1 | 1 | 1 | | D2596 | 205 WEB |
| 11 | 1 | 1 | 1 | | D2855 | AFT CAP |
| 12 | 1 | 1 | | | D3564-5 | WEARSHOE |
| 13 | 1 | 1 | | | D3564-9 | WEARSHOE |
| 14 | 1 | 1 | | | D3564-11 | WEARSHOE |
| 15 | 1 | 1 | | | D3564-13 | WEARSHOE |
| 16 | 2 | 2 | | | D3566-1 | GASKET |
| 17 | 1 | 1 | | | D3566-5 | GASKET |
| 18 | 1 | 1 | | | D3566-13 | GASKET |
| 19 | | | 1 | | D4406-041 | WEARPLATE ASSEMBLY |
| 20 | | | 1 | | D4406-043 | WEARPLATE ASSEMBLY |
| 21 | 50 | 50 | | | ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130 | INSERT |
| 22 | 50 | 50 | | | AN3C4A | BOLT |
| 23 | 2 | 2 | 2 | | AN3-5A | BOLT |
| 24 | | | 8 | | AN4-45A | BOLT |
| 25 | 50 | 50 | | | NAS1149C0332R | WASHER (AN960C10L) |
| 26 | 2 | 2 | 2 | | NAS1149D0332J | WASHER (AN960JD10L) |
| 27 | | | 8 | | MS21042-4 | NUT (OR MS21042L4) |

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY (-041/-047) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT ASSEMBLY (-045) GREEN SANDEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 34.5 lbs
D2580-045 = 34.5 lbs
D2580-047 = 37.7 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL 20.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241-291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

DEO ATTACHED

RELEASED
2011-08-29

| | | | |
|------------|---|---|--------------|
| E | ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1) | RF | 11.06.21 |
| D | CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183 | PH | 07.04.05 |
| C | REDRAWN, INCLUDED DEO 9094/9097 | CP | 98.08.26 |
| B | AS MANUFACTURED | DS | 96.12.02 |
| A | NEW ISSUE | DS | 96.09.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | # | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | 10 | DRAWING NO. | REV. E |
| MFG. APPR. | 10 | D2580 | SHEET 1 OF 8 |
| APPROVED | 10 | TITLE | SCALE |
| DE APPR. | 10 | 205 SKIDTUBE ASSEMBLY | NTS |
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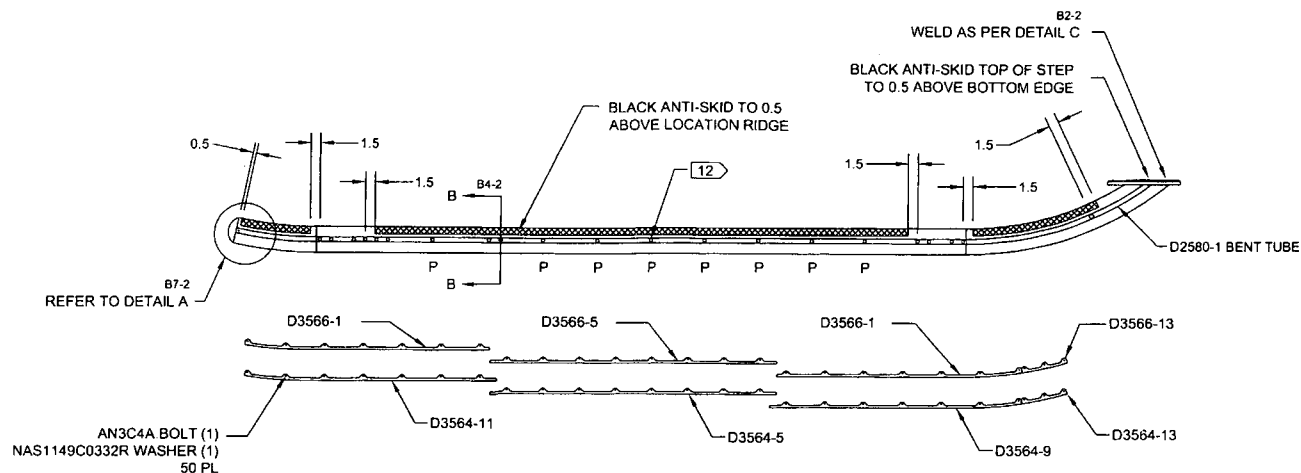
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

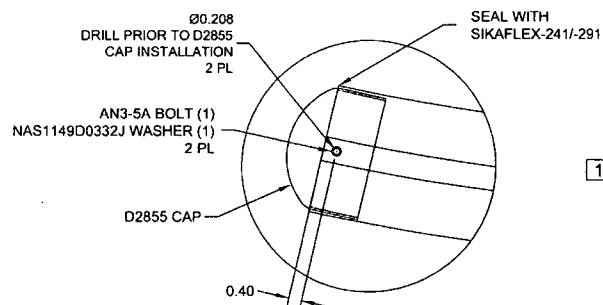
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NOTE: Date & initial all entries

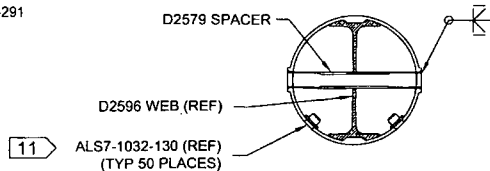


D2580-041 ASSEMBLY DETAIL

DETAIL A C7-2
SCALE 5X

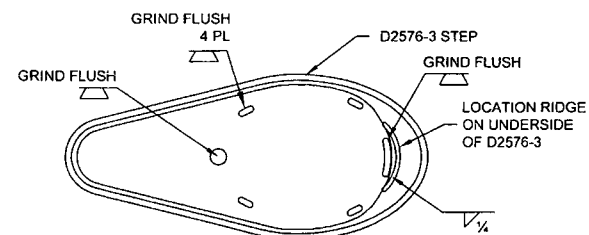


SECTION B-B D5-2
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DETAIL C D3-2
SCALE 5X



| | | | |
|------------|----------|---|--------------|
| DESIGN | 4 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 10 | DRAWING NO. | REV. E |
| MFG. APPR. | 11 | D2580 | SHEET 2 OF 8 |
| APPROVED | 12 | TITLE | SCALE |
| DE APPR. | 13 | 205 SKIDTUBE ASSEMBLY | NTS |
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DEO ATTACHED

RELEASED

2011-08-29

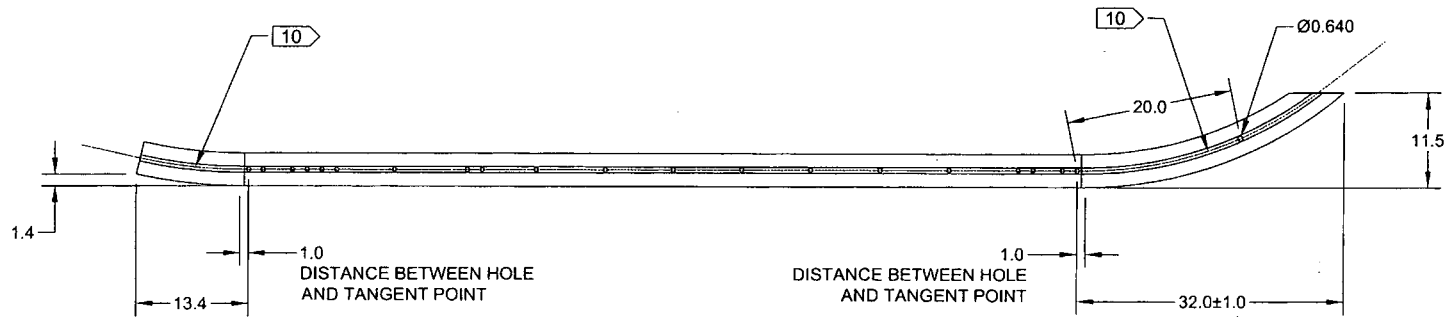
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

DEO ATTACHED

RELEASED
2011-08-28

| | | | |
|------------|----------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 10 | DRAWING NO. | REV. E |
| MFG. APPR. | 10 | D2580 | SHEET 3 OF 8 |
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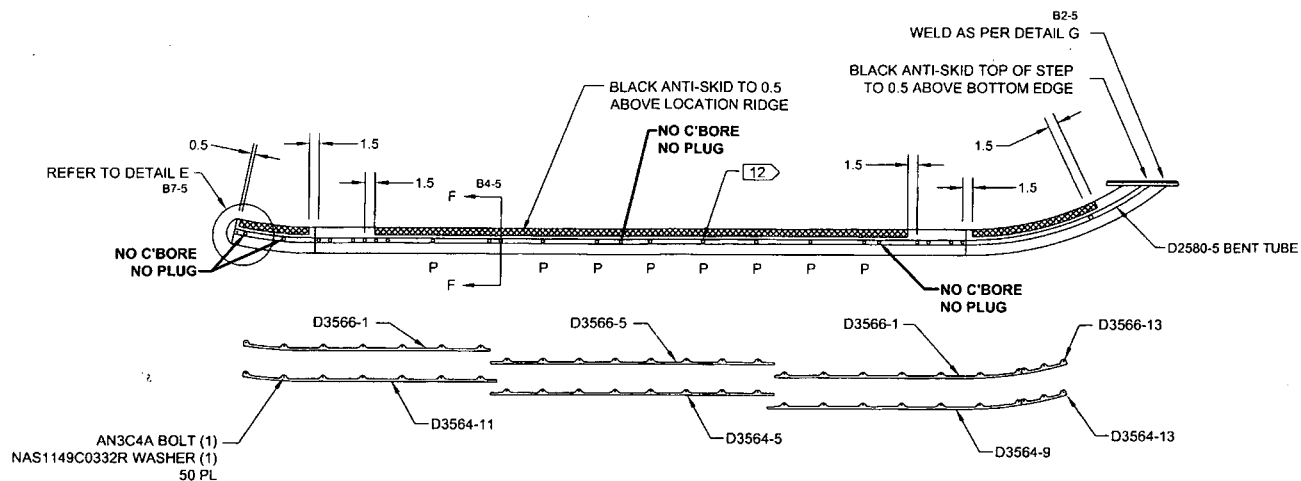
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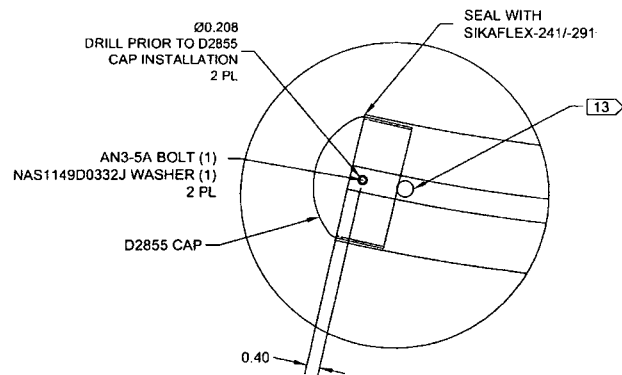
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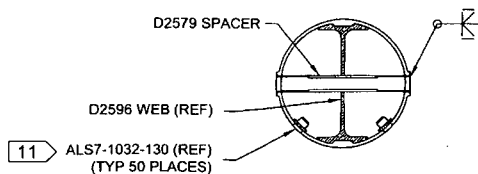


D2580-045 ASSEMBLY DETAIL

DETAIL E
SCALE 5X

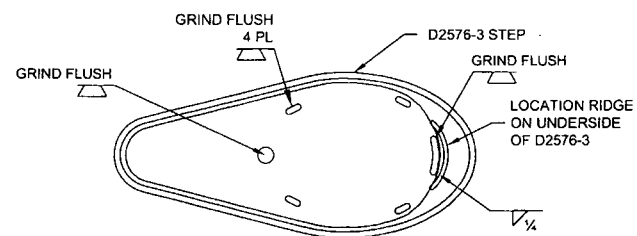


SECTION F-F
SCALE 5X



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (24 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DETAIL G
SCALE 5X



DEO ATTACHED
RELEASED
2011-08-29

| | | | |
|--|-----------|--|--------------|
| DESIGN | <i>RF</i> | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>AP</i> | DRAWING NO. | REV. E |
| MFG. APPR. | <i>AS</i> | D2580 | SHEET 4 OF 8 |
| APPROVED | <i>AP</i> | TITLE | SCALE |
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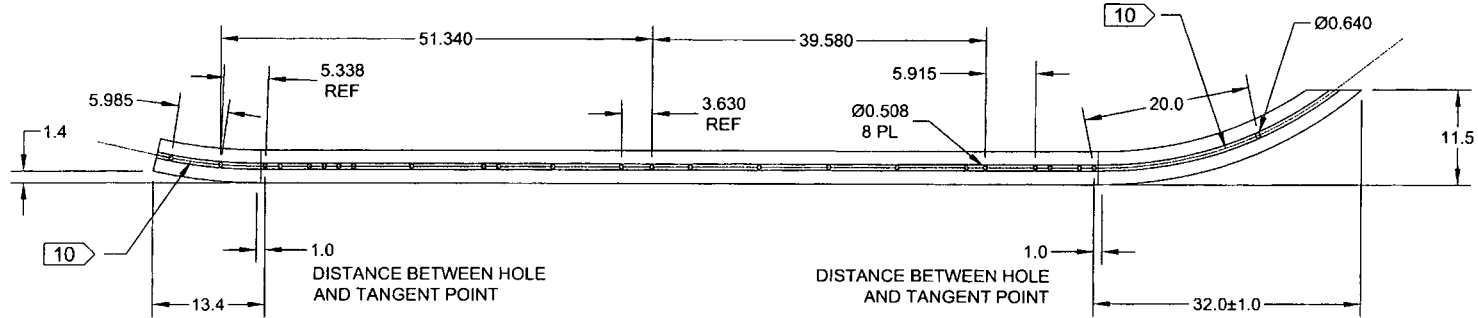
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

DEO ATTACHED
RELEASED
2011-08-29
ND

| | | | |
|------------|----------|--|--------------|
| DESIGN | # | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | 10 | DRAWING NO. | REV. E |
| MFG. APPR. | 10 | D2580 | SHEET 5 OF 8 |
| APPROVED | 10 | TITLE | SCALE |
| DE APPR. | 10 | 205 SKIDTUBE ASSEMBLY | NTS |
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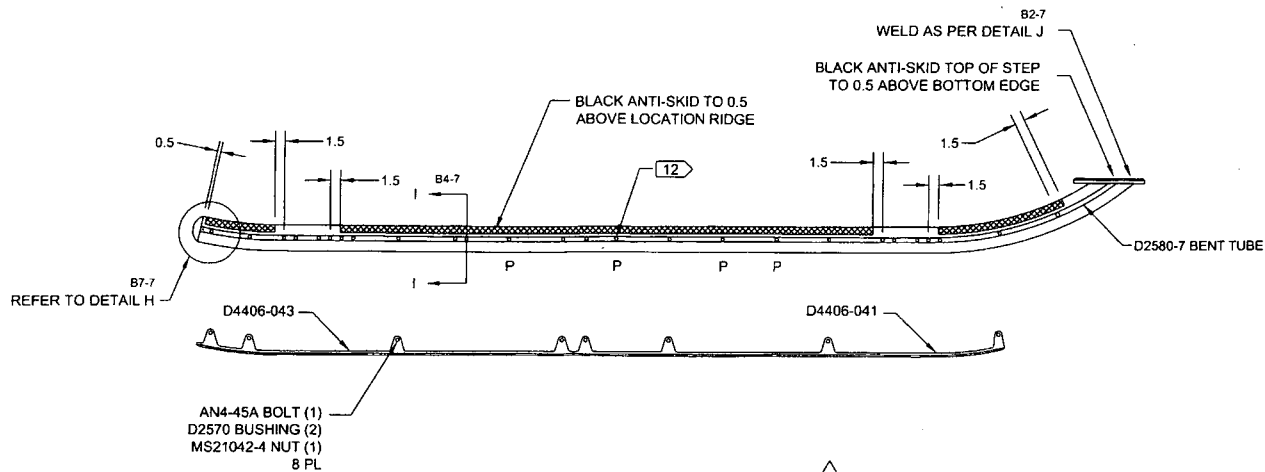
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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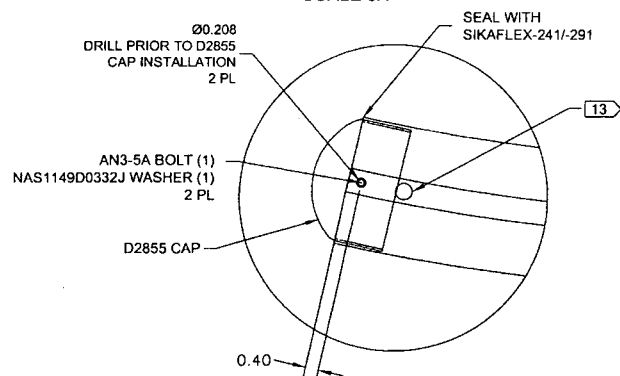
NOTE: Date & initial all entries



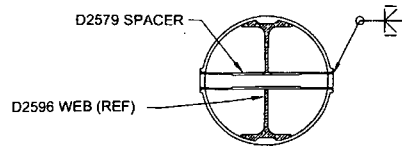
D2580-047 ASSEMBLY DETAIL E

**DEO ATTACHED
RELEASED**
2011-08-29

DETAIL H C6-7
SCALE 5X

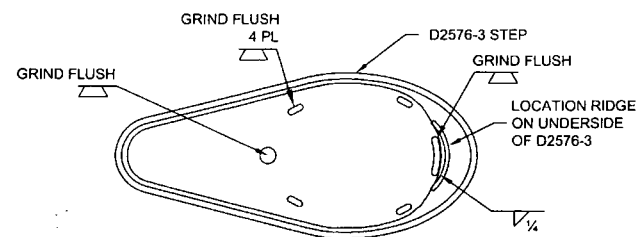


SECTION I-I D5-7
SCALE 5X



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (25 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DETAIL J D3-7
SCALE 5X



| | | | |
|--|----------|--|--------------|
| DESIGN | # | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AP | DRAWING NO. | REV. E |
| MFG. APPR. | AP | D2580 | SHEET 6 OF 8 |
| APPROVED | AP | TITLE | SCALE |
| DE APPR. | AP | 205 SKIDTUBE ASSEMBLY | NTS |
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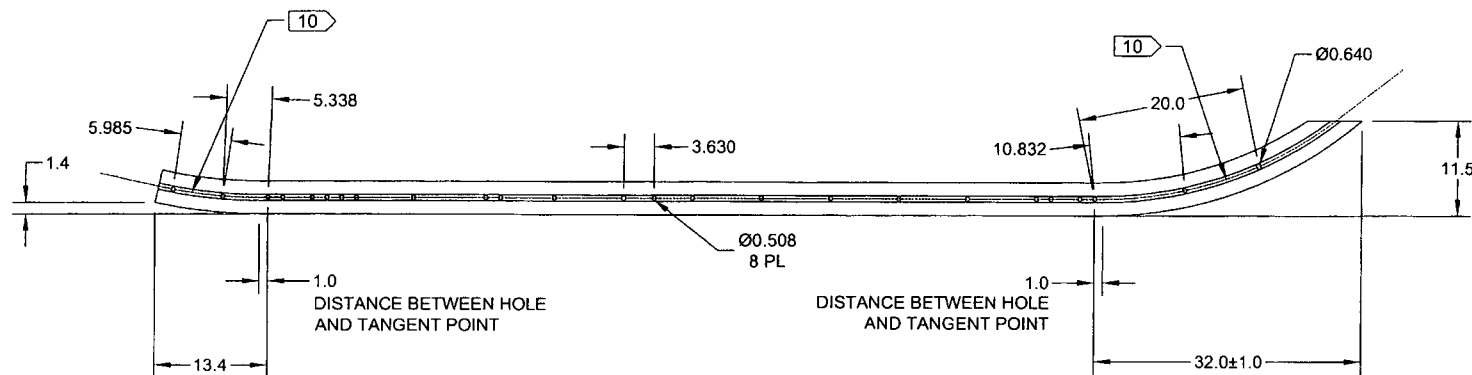
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)



DEO ATTACHED

RELEASED
2011-08-29

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|------------|----------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 10 | DRAWING NO. | REV. E |
| MFG. APPR. | 10 | D2580 | SHEET 7 OF 8 |
| APPROVED | 10 | TITLE | SCALE |
| DE APPR. | 10 | 205 SKIDTUBE ASSEMBLY | NTS |
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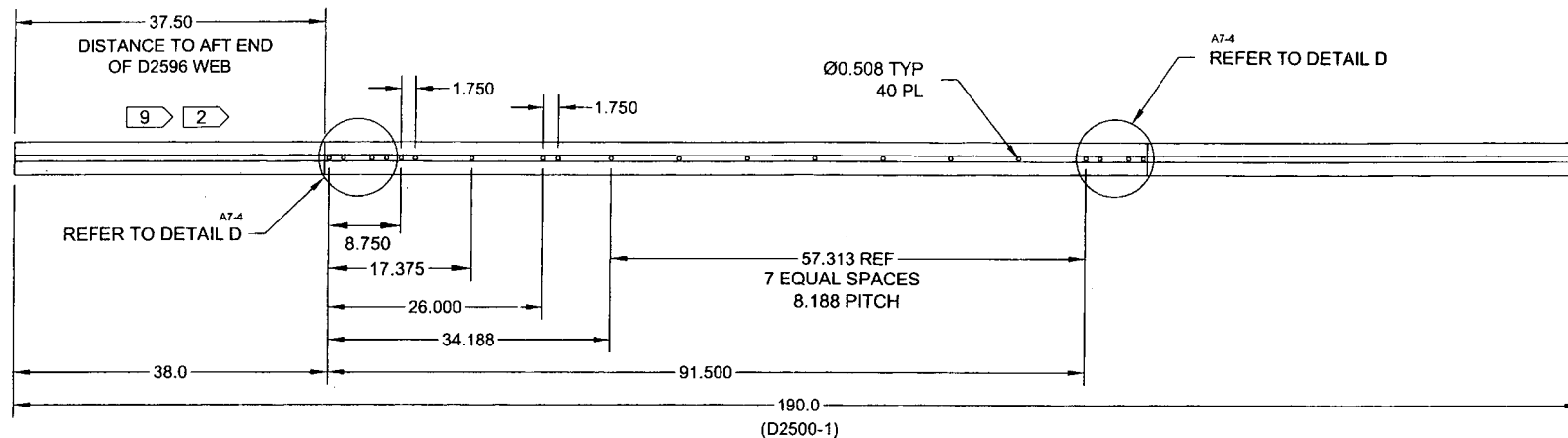
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

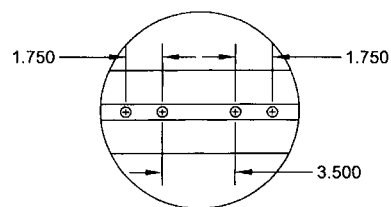
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D2580-101 TUBE



DETAIL D D3-4
SCALE 5X C7-4

DEO ATTACHED
RELEASED
R 2011-08-29
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|------------|----------|---|--------------|
| DESIGN | # | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 1P | DRAWING NO. | REV. E |
| MFG. APPR. | 1P | D2580 | SHEET 8 OF 8 |
| APPROVED | 1P | TITLE | SCALE |
| DE APPR. | # | 205 SKIDTUBE ASSEMBLY | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|----------------------|--------------------------------|----------------------|---|-------------------------|---------------------------|--------------|
| DRAWING NO. D2580 | TITLE 205 SKIDTUBE ASSEMBLY | REV. E | DART AEROSPACE LTD ENGINEERING ORDER | D.E.O. NO. D2580-E-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>UP</i> | CHECKED <i>ASS</i> | MFG. APPR. <i>ER</i> | APPROVED <i>#</i> | DE APPR. <i>#</i> | | |
| DATE 11.12.13 | DATE 11.12.13 | DATE 11.12.13 | DATE 11.12.13 | DATE 11.12.13 | | |

PURPOSE:

CHANGE ALL C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

WAS

| QTY | QTY | QTY | PART NUMBER | DESCRIPTION |
|------|------|------|-------------|-------------------|
| -041 | -045 | -047 | | |
| 20 | 24 | 25 | D2579 | CROSS BOLT SPACER |

IS

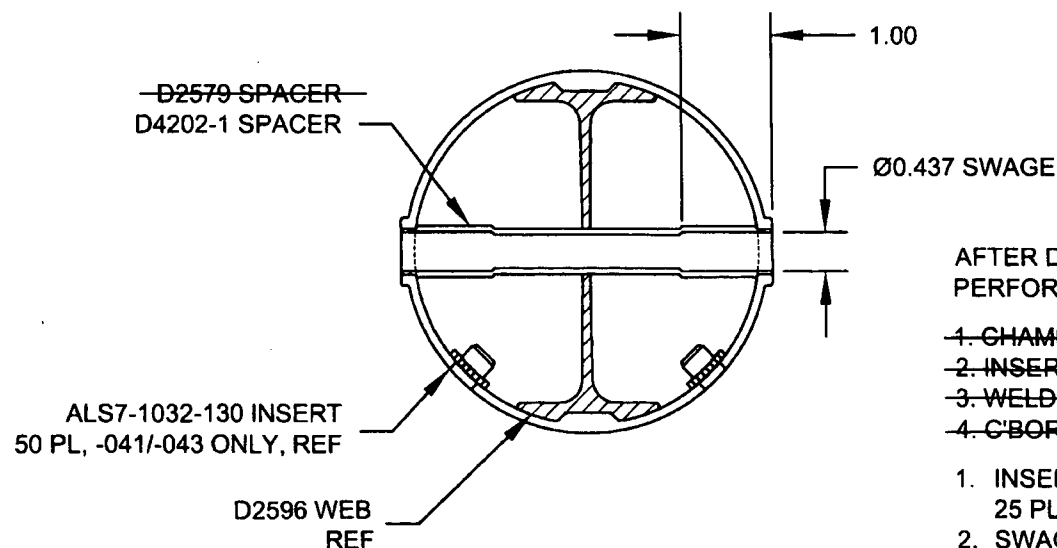
| | | | | |
|----|----|----|---------|-------------------|
| | 4 | | * D2579 | CROSS BOLT SPACER |
| 20 | 20 | 25 | D4202-1 | SPACER |

SECTION B-B, SECTION F-F, & SECTION I-I ARE AMENDED AS FOLLOWS
FOR ALL HOLES THAT WERE ORIGINALLY C'BORED:

*** FOR -045 SKIDTUBE ONLY:**

WELD 4X D2579 SPACERS PER DWG
IN LOCATIONS MARKED "NO C'BORE".
REF SHEET 4 OF DWG.

RELEASED
2011-12-14



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 20 PL (-045) OR 25 PL (-047)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION B-B, F-F, I-I
NOT TO SCALE

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & Initial all entries